

**Work Order ID 58087**

April 22, 2010 2:55:11 PM



Page 1

Item ID: D3836-042

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly (Basket Lid, RH)

Stop



Start Date: 22/04/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 29/04/2010 Req'd Qty: 2.00



Customer:

Reference:

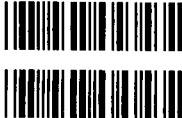
Approvals:

Process Plan: *ff*

Date: 10-4-22 Tooling:

Date:

Run Start



QC:

Date: \_\_\_\_\_

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr	Revision Nbr	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
D3836	Rev A								

100

0.00



Large Fab

Large Fab

Memo 0.00

Large Fab

1- cut D3836-2 and D3836-3 rib as per dwg D3836

2- remove identification markings

3- deburr

4- weld D3836-2 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836

5- weld D2327-3 spacer bushing as per dwg D3836

A/R ER316 S.S. Rod Batch: *111679*

6- grind weld flush where indicated on dwg

*SAD 10-05-05*

*JL* 10.05.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 58087**

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130



QC

Quality Control

Operation  
Description

QC9- Inspect visual per QSI004- Fusion Welds

Set Up/  
Run Hours

0.00

Draw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberReject  
NumberInsp.  
Stamp

(2) DD 10.05.07

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S.05/07

(2) -042

Memo

0.00

150



Packaging

Packaging

Identify as per dwg &amp; Stock Location: WR

0.00

SAD  
10-05-07

(2)

Memo

0.00

W/O:		WORK ORDER CHANGES					
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**Work Order ID 58087**

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Page 3

Item ID: D3836-042

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly (Basket Lid, RH)

Stop



Start Date: 22/04/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 29/04/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

160

Operation  
Description

QC21- Final Inspection - Work Order Release

Set Up/  
Run Hours

0.00

Draw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberReject  
Stamp

QC

Quality Control

Memo

0.00

10/05/07  
MF

10-5-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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NOTE: Date & initial all entries

**Picklist Print**

April 22, 2010 2:55:16 PM

Page 1

**Work Order ID:** 58087**Parent Item:** D3836-042**Parent Item Name:** Rib Assembly (Basket Lid, RH)**Comments:** IPP Rev:A 08-12-01 new issue DD verified by:eC**Start Date:** 22/04/2010**Required Date:** 29/04/2010**Start Qty:** 2.00**Required Qty:** 2.00

<b>Component Item ID/ Item Name</b>	<b>Replacement Item ID</b>	<b>Mfg/ Purch</b>	<b>Bin Item</b>	<b>Primary Location</b>	<b>Last Location</b>	<b>Route Seq ID</b>	<b>Unit of Measure</b>	<b>Qty on Hand</b>	<b>Remaining Qty To Pick</b>	<b>Qty Issued</b>	<b>Date Issued</b>	<b>Status</b>
---	--------------------------------	-----------------------	---------------------	-----------------------------	--------------------------	-------------------------	----------------------------	------------------------	----------------------------------	-----------------------	------------------------	---------------

D2327-3



Spacer Bushing

Manufactured

No

100

Each

31.0000

2.0000



GCO-05-05

**Warehouse****Location**

Main Warehouse

WA

**Loc Qty****Loc Code**

31

57186

11

57790

20

M304TS0.750W.065



304 SQ Tube .75x.75x.065W

Purchased

No

100

f

8.6105

3.7491



(2)



SAD 10-05-05

**Warehouse****Location**

Main Warehouse

WA

**Loc Qty****Loc Code**

8.610463158

111148

2.7967

113956

2.863

114137

2.95076316

M114482

3.7491

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

8

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2

1

D

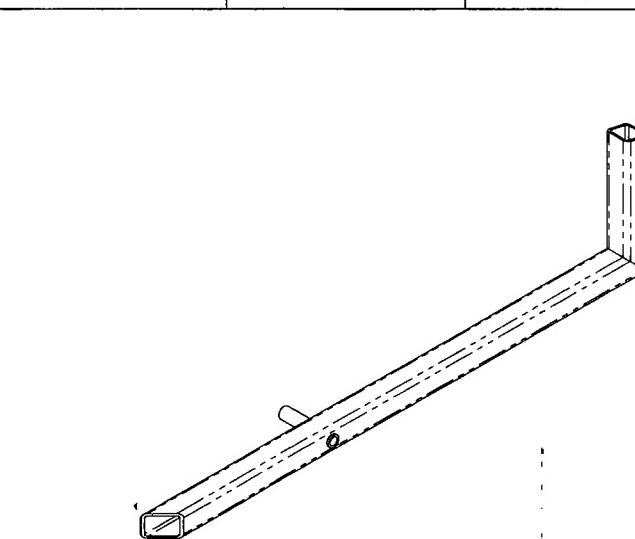
D

C

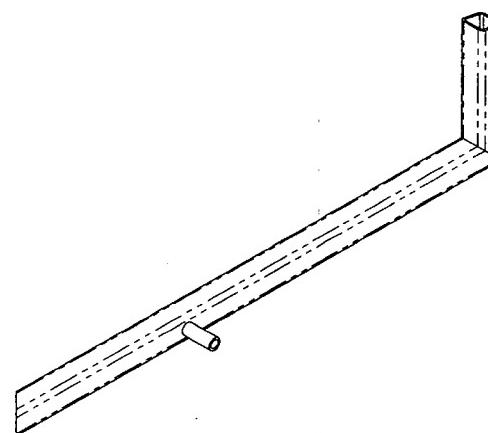
C

B

B



D3836-042 RIB ASSY (BASKET LID, RH)



D3836-041 RIB ASSY (BASKET LID, LH)

A

A

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.99 lbs EACH
- 8) WELD PER DART QSI 004

ITEM	QTY 041	QTY 042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB

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ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 58087

*BD 10-4-22*

**RELEASED**  
*08/11/18 MP*

A	NEW ISSUE	MB	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>12/23</i>		
DRAWN			
CHECKED	<i>12/23</i>		
MFG. APPR.	<i>12/23</i>		
APPROVED	<i>12/23</i>		
DE APPR.	<i>12/23</i>		
DATE	08.09.24		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3836 REV. A  
SHEET 1 OF 3

TITLE RIB ASSY (BASKET LID) SCALE NTS

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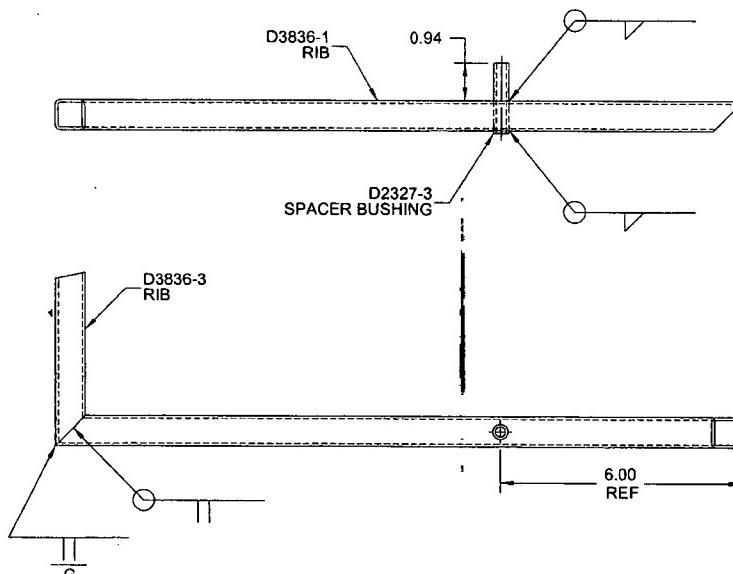
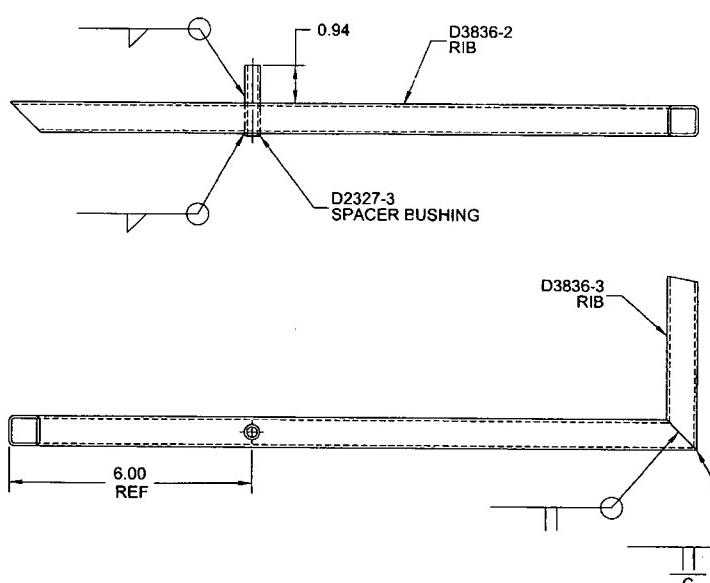
3

2

1

D

D

D3836-041 RIB ASSY (BASKET LID, LH)D3836-042 RIB ASSY (BASKET LID, RH)

w/o 58087

RELEASED  
08/11/2018 JMW

8

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A

A

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>MS</i>	REV. A
MFG. APPR.		SHEET 2 OF 3
APPROVED	<i>AD</i>	TITLE
DE APPR.		SCALE
DATE	08.09.24	NTS

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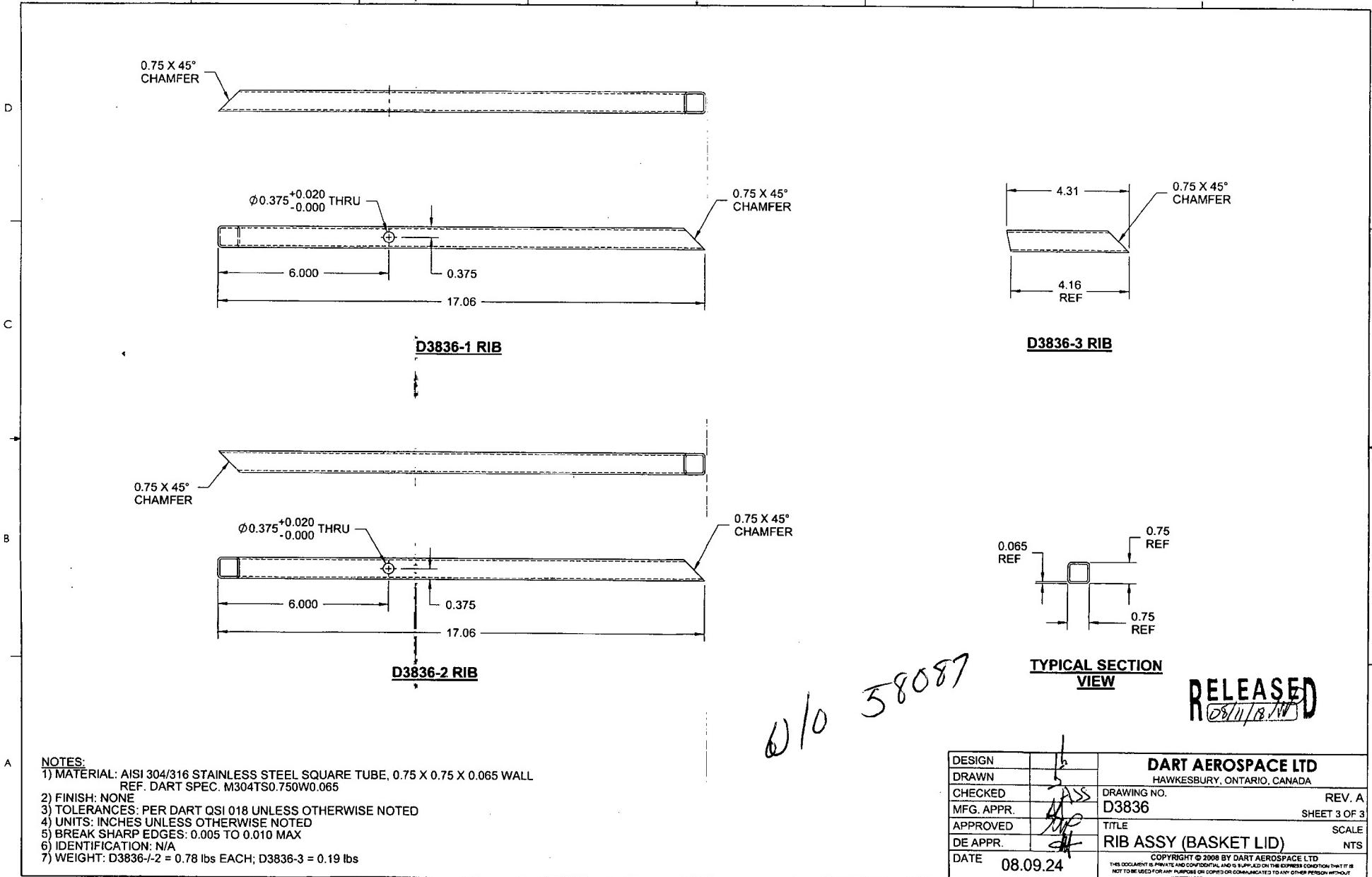
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8 7 6 5 4 3 2 1


*RELEASED*  
*08/11/08*

8 7 6 5 4 3 2 1

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